



Dart Aerospace Ltd.
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D5134-041
Job Sheet 191180



Part No: D5134-041

Job Qty: 4 pcs

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/22/19

Job Tracking No:

Due Date: 3/22/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		3/22/19	0.00	0.24	Bandsaw - 1		<i>lll</i>
110	HAAS 4 Axis - B4B	4 pcs		3/22/19	0.00	9.30	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		<i>lll</i>
120	QC 2	4 pcs		3/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

[illegible]

130 QC 8	4 pcs	3/22/19	0.00 0.00	QC 2 - 57				
				QC 2 - 62				
				QC 2 - 63				
				QC 2 - 8				
				QC 2 - 66	DAS			
				QC 2 - 64	64			
				QC 8 - 12	9-89			
				QC 8 - 14	mk 19/03/17			
				QC 8 - 17				
				QC 8 - 20				
				QC 8 - 25				
				QC 8 - 3				
				QC 8 - 32				
				QC 8 - 33				
				QC 8 - 35				
				QC 8 - 39				
				QC 8 - 4				
				QC 8 - 44				
				QC 8 - 45				
				QC 8 - 49				
				QC 8 - 58				
				QC 8 - 8				
				QC 8 - 9				
				QC 8 - 68				
				QC 8 - 67				
				QC 8 - 1 (A)				
				QC 8 - 47				
135 Handfinish - 1-1 Chemical-B4B	4 pcs	3/22/19	0.00 0.27	Handfinish - 1 - 1 - B4B				
				Handfinish - 1 - 2 - B4B				
				Handfinish - 1 - 3 - B4B				
				Handfinish - 1 - 4 - B4B				
				Handfinish - 1 - 5 - B4B				
				Handfinish - 1 - 6 - B4B				
				Handfinish - 1 - 7 - B4B				
				Handfinish - 1 - 8 - B4B				
				Handfinish - 1 - 9 - B4B				
				Handfinish - 1 - 10 - B4B	D.R 19/03/18			
				Handfinish - 1 - 11 - B4B				
				Handfinish - 1 - 12 - B4B				
				Handfinish - 1 - 13 - B4B				
				Handfinish - 1 - 14 - B4B				
				Handfinish - 1 - 15 - B4B				
				Handfinish - 1 - 16 - B4B				
				Handfinish - 1 - 17 - B4B				
				Handfinish - 1 - 18 - B4B				
				Handfinish - 1 - 19 - B4B				
				Handfinish - 1 - 20 - B4B				
				Handfinish - 1 - 21 - B4B				
								Plex 2/22/19 12:46 PM dart.white.jesse

Entered: _____ Date: _____

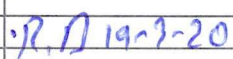
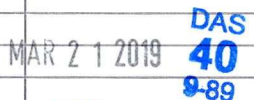
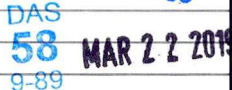


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Handfinish - 1 - 22 - B4B	
137 QC 7	4 pcs	3/22/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
140 Spray Paint - 2 - B4B	4 pcs	3/22/19	0.00 1.04	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
150 QC 14	4 pcs	3/22/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
160 Small Fab - 2 - B4B	4 pcs	3/22/19	0.00 0.58	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
170 QC 5	4 pcs	3/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				Plex 2/22/19 12:46 PM dart.white.jesse	

R.D 19-2-20

MAR 21 2019
DAS 40
9-89

MAR 22 2019
DAS 58
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)																													
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				Completed By																															
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				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong																																
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☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																	
		Other/Details:																																	

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	MAR 2 2 2019 DAS 40
				QC 5 - 50	9-89
				QC 5 - 30	
180	Packaging 3-1 - Stock - B4B	4	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	4	3/22/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - Bandsaw - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION****

Descriptions: 110 - HAAS CNC Vertical Machine - Mill as per Dwg and folio FB342

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

135 - Chemical Conversion Coat per QSI005 4.1

137 - QC7-Inspect Chemical Conversion Coat

140 - Spray Paint / NDT Room ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI

BATCH 143304 PAINT AS PER DWG AND QSI BATCH: 146086

150 - QC14- Inspect Spray Paint

160 - Small Fab - install bushings as per dwg

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____ -LOCATION : LG054

190 - QC21- Final Inspection - Work Order Release)

MAR 2 5 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Date : _____		Sequence #:		QTY Affected :		MRB (QSI042)
Description Work Order Deviation				Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
		Other/Details:				

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	1.7080 ft (.427 ea)	100-Bandsaw - 1	5076663
NAS77C6-021	Bushing	8 Ea (2 ea)	160-Small Fab - 2 - B4B	FM134833

MAT
used.
1.724'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B3.000X4.000	2	7	0
160-Small Fab - 2 - B4B	NAS77C6-021	8	215	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support Assembly, LH	0.360Inches ± 0.030	0.390 0.330		
2	Damper Support Assembly, LH	0.188Inches + 0.005 - 0.001	0.193 0.187		
3	Damper Support Assembly, LH	0.257Inches + 0.006 - 0.001	0.263 0.256		
4	Damper Support Assembly, LH	1.932Inches ± 0.010	1.942 1.922		
5	Damper Support Assembly, LH	0.632Inches ± 0.010	0.642 0.622		
6	Damper Support Assembly, LH	0.632Inches ± 0.010	0.642 0.622		
7	Damper Support Assembly, LH	0.730Inches ± 0.010	0.740 0.720		
8	Damper Support Assembly, LH	0.500Inches + 0.000 - 0.010	0.500 0.490		
9	Damper Support Assembly, LH	0.100Inches ± 0.010	0.110 0.090		
10	Damper Support Assembly, LH	0.728Inches ± 0.010	0.738 0.718		
11	Damper Support Assembly, LH	0.250Inches ± 0.030	0.280 0.220	Radius	
12	Damper Support Assembly, LH	0.630Inches ± 0.030	0.660 0.600	Radius	
13	Damper Support Assembly, LH	0.063Inches ± 0.010	0.073 0.053	Radius	
14	Damper Support Assembly, LH	0.117Inches ± 0.010	0.127 0.107		
15	Damper Support Assembly, LH	0.177Inches ± 0.010	0.187 0.167		
16	Damper Support Assembly, LH	0.841Inches ± 0.010	0.851 0.831		
17	Damper Support Assembly, LH	0.208Inches ± 0.010	0.218 0.198		
18	Damper Support Assembly, LH	0.208Inches ± 0.010	0.218 0.198		
19	Damper Support Assembly, LH	0.860Inches ± 0.010	0.870 0.850		
20	Damper Support Assembly, LH	1.471Inches ± 0.010	1.481 1.461		
21	Damper Support Assembly, LH	0.130Inches ± 0.030	0.160 0.100	Radius	

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		Other/Details:			

